

Work Order ID 71272

Friday, June 24, 2011 3:43:42 PM

Page 1

Item ID: D3174-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 6/24/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3174

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3174 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

11-6-27

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-6-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 11/6/27

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Deburr if necessary

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location WA

Memo

0.00

0.00

*****STOCK IN BASKET CELL*****

SAD 11-06-27

12

W/O:		WORK ORDER CHANGES					
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Page 3

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Approvals:

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Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28
11-06-28
17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, June 24, 2011 3:43:46 PM

Page 1

Work Order ID: 71272

Parent Item: D3174-1

Parent Item Name: Mounting Lug





Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: ☐A☐03.01.29☐New issue☐KJ/RF☐
IPP Rev:B 08-08-19 now made on water jet DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	20.7000	0.0408	0.515368			
304/316 Sheet .063													

B1-C-17

Location	Loc Qty	Loc Code
MAT020	20.7	
117275	2.3	
117653	18.4	

117275

12

W/O:		WORK ORDER CHANGES					
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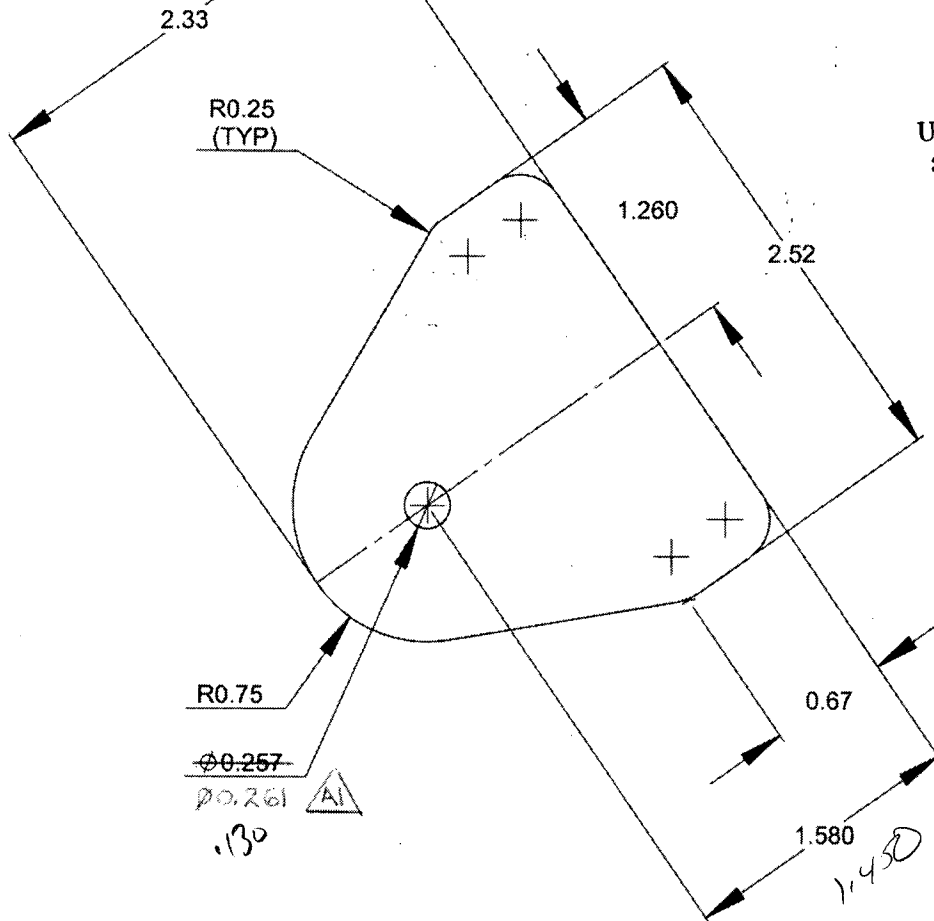
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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3174	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	
AI	03.01.21 <i>UP</i>	Ø 0.261 WAS Ø 0.257	

RELEASED
02.12.03 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71272

PL11-06-27

D3174-1 MOUNTING LUG

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.063 THICK
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005-0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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